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## LORD® ENGINEERED ADHESIVES

### Applications

Metal Bonding  
Composite Bonding  
Sign Assembly

### Products

Acrylic Adhesives  
Urethane Adhesives  
Epoxy Adhesives  
Cyanacrylate Adhesives  
Adhesion Enhancers/Surface  
Modifiers  
Dispensing Systems

## LORD® Engineered Adhesives

### LORD 201 Acrylic Adhesive

LORD® 201 Acrylic Adhesive when mixed with LORD Accelerator 17 or 19 creates an adhesive system that will bond a wide variety of prepared or unprepared metals and plastics. LORD 201 Acrylic Adhesive in combination with LORD Accelerator 17 or 19 replaces welding, brazing, riveting and other mechanical fastening methods.

LORD 201 Acrylic Adhesive can be mixed with either LORD Accelerator 17 or LORD Accelerator 19. LORD Accelerator 19 is available in off-white or black.

### Product Information

#### TYPICAL PROPERTIES

Appearance	Off-white Liquid
Work Time, min	5-8
Handling Time, min	12-16
Cure Time, hr	24*
Typical Viscosity, cP	15,000-55,000
Density, lb/gal (kg/m <sup>3</sup> )	8.5-8.7 (1019-1042)

\* Reaches 90% of ultimate strength after 2 hours.

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## LORD® ENGINEERED ADHESIVES

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## LORD® Engineered Adhesives

### LORD 202 Acrylic Adhesive

LORD® 202 Acrylic Adhesive when mixed with LORD Accelerator 4, 17, 18 or 19 creates a fast curing adhesive system that will quickly bond a wide variety of prepared or unprepared metals and plastics. LORD 202 Acrylic Adhesive in combination with the recommended accelerator replaces welding, brazing, riveting and other mechanical fastening methods.

LORD 202 Acrylic Adhesive can be mixed with either LORD Accelerator 4, LORD Accelerator 17, LORD Accelerator 18 or LORD Accelerator 19. LORD Accelerator 4 is a no-mix accelerator applied to the substrate before the acrylic adhesive. LORD Accelerators 17, 18 and 19 must be mixed into the acrylic adhesive prior to application. LORD Accelerator

### TYPICAL PROPERTIES

<b>Appearance</b>	Off-white Liquid
<b>Work Time, min</b>	1-2
<b>Handling Time, min</b>	2-4
<b>Cure Time, hr</b>	24*
<b>Typical Viscosity, cP</b>	8,000-32,000
<b>Density, lb/gal (kg/m<sup>3</sup>)</b>	9.6-10.35 (1150-1240)

\* Reaches 90% of ultimate strength after 2 hours.

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## LORD® Engineered Adhesives

### LORD® ENGINEERED ADHESIVES

#### Applications

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Composite Bonding  
Sign Assembly

#### Products

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Urethane Adhesives  
Epoxy Adhesives  
Cyanocrylate Adhesives  
Adhesion Enhancers/Surface  
Modifiers  
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### LORD 204 Acrylic Adhesive

LORD® 204 Acrylic Adhesive when mixed with LORD Accelerator 17 or 19 creates an adhesive system that will bond a wide variety of prepared or unprepared metals and plastics. LORD 204 Acrylic Adhesive in combination with LORD Accelerator 17 or 19 replaces welding, brazing, riveting and other mechanical fastening methods.

LORD 204 Acrylic Adhesive can be mixed with either LORD Accelerator 17 or LORD Accelerator 19. LORD Accelerator 19 is available in off-white or black.

#### Product Information

#### TYPICAL PROPERTIES

Appearance	Off-white Paste
Work Time, min	6-8
Handling Time, min	12-16
Cure Time, hr	24*
Typical Viscosity, cP	100,000-300,000
Density, lb/gal (kg/m <sup>3</sup> )	8.7-9.3 (1042-1114)

\* Reaches 90% of ultimate strength after 2 hours.

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## LORD® Engineered Adhesives

### LORD® ENGINEERED ADHESIVES

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#### Products

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### LORD 206 Acrylic Adhesive

LORD® 206 Acrylic Adhesive when mixed with LORD Accelerator 4, 17 or 19 creates a long working time adhesive system that bonds a wide variety of prepared or unprepared metals and plastics. LORD 206 acrylic adhesive in combination with the recommended accelerator replaces welding, brazing, riveting and other mechanical fastening methods.

LORD 206 Acrylic Adhesive can be mixed with either LORD Accelerator 4, LORD Accelerator 17 or LORD Accelerator 19. LORD Accelerator 4 is a no-mix accelerator applied to the substrate before the acrylic adhesive. LORD Accelerators 17 and 19 must be mixed into the acrylic adhesive prior to application. LORD Accelerator 19 is available in off-white or black.

#### TYPICAL PROPERTIES

Appearance	Off-white Liquid
Work Time, min	12-14
Handling Time, min	45-60
Cure Time, hr	24
Typical Viscosity, cP	20,000-80,000
Density, lb/gal (kg/m <sup>3</sup> )	8.5-8.7 (1019-1042)

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